

JUN 23 2018

FW



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-692-041
Job Sheet 179842



Part No: D135-692-041

Job Qty: 2 ea

Part Name: EC135 Bearpaw Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/22/18

Job Tracking No:

Due Date: 6/29/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG DSI9400 REV A, DSI9750 REV A IPP Rev:A new issue ECN1089 08-02-04 DD verified by:EC IPP
Rev:B ECN 1132 08-02-20 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 28 2018
110	Packaging	2 pcs	6/29/18	6/29/18	0.00	0.00	Packaging1-1		JUN 28 2018
120	QC	2 pcs	6/29/18	6/29/18	0.00	0.00	QC4		9-89
130	Packaging	2 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1		
135	DC	2 pcs	6/29/18	6/29/18	0.00	0.00	DC		
140	QC21-FG	2 Ea	6/29/18	6/29/18	0.00	0.00	QC21		21 JUL 04 2018

Part Op 130 - Identify and pack for shipping as per PPP D135-692-041 CHG001 PPP Rev: Fg128
Descriptions: 135 - Photocopy bluefile and create labels per PPP D135-692-041 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	8 Ea (4 ea)	90-Start up Operation	5070193
AN4-13A	Bolt	16 Ea (8 ea)	90-Start up Operation	5067892
D2529	Washer	16 Ea (8 ea)	90-Start up Operation	5035658
D3719-041	Wearplate Assembly	4 Ea (2 ea)	90-Start up Operation	5090708
MS21042L4	Nut	24 Ea (12 ea)	90-Start up Operation	5067898
NAS1149D0463J	Washer	16 Ea (8 ea)	90-Start up Operation	5067900

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	8	390	0
	AN4-13A	16	911	0
	D2529	16	1,785	0
	D3719-041	4	4	0
	MS21042L4	24	2,267	0
	NAS1149D0463J	16	3,932	0

Part Specifications

4/105 Specifications could not be found.

DQA: _____ Date: _____
 QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS		MRB (QS1042) Approval ☐ Completed By _____	
Date : _____ Step #: _____		QTY Effective : _____		Disposition _____			
Description Work Order Deviation							

Container No: S085335

Part: D135 - 692 - 041
Job No: 179842
Serial No/Batch: S085335

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____

DART AEROSPACE

Lead hand / Supervisor Approval Verification _____

QC / QA Coordinator Approval _____

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Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Set-up	BOM/Route	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Contamination	Countersink	Cut Too Short	Instructions Incomplete/Unclear
Design	Operator	Bending									
Doc/Data	Offset/Setup	Centre Not Concentric									
Equip/Tooling	Supplier	Cracks									
Handling/Pre	Training	Crimp/Kink/Ripple/Wave									
Material	Use for Testing	Cuffs									
Internal Transport	Poor Information	Crushing									
Tribal Knowledge	Rushing	Heat Treat									
LOA	Product Improvement	Wave/Twist in Tube									
Substation	Process Improvement	Marks/Chatter									
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
		OTHER : _____									

DART AEROSPACE

Positioned Wrong outside Dimensions over/Under tolerance
 rt Incorrect
 rt Lost/Missing
 rt Moved

Drawing ☐
 Finish ☐
 Misread ☐
 Turning Sequence ☐

Mislabeled ☐
 Fit/Function ☐
 Misaligned/off center ☐



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004155	S085332	AN4-11A	Bolt	s070193	ST344	8
004155	S085331	AN4-13A	Bolt	s067892	ST344	16
004155	S085327	D2529	Washer	S035698	ST008	16
004155	S070708	D3719-041	Wearplate Assembly	S072886	ST186	4
004155	S085321	MS21042L4	Nut	s067898	ST303	24
004155	S085320	NAS1149D0463J	Washer	s067900	ST263	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/28/18 2:03 PM dart.quirion.sonia

3.0 PARTS LIST

The DSI 9750-011 Clamp Relocation Kit can be procured from Dart to install D135-692-041 on D135-692-011 at CHG 002 and earlier, and includes hardware for Qty 2x skid tubes.

Qty -011	Part Number	Description
X	DSI 9750-011	Clamp Relocation Kit
8	D2529	WASHER
4	AN4-11A	BOLT
4	MS21042L4	NUT

The parts list for IIN-D135-692 and ICA-D135-692 is amended as follows:

Qty -011	Qty -041	Part Number	Description
X		D135-692-011	BEARPAW INSTALLATION
	X	D135-692-041	WEARPLATE KIT
4		D2182B060	RUBBER CUSHION
8		D2274	RADIUS BLOCK
2		D3049-1	BEARPAW
8	8	D2529	WASHER
4		D2519	CLAMP
	2	D3719-041	WEARPLATE
	4	AN4-11A	BOLT
8	8	AN4-13A	BOLT
8	12	MS21042L4	NUT (OR MS21042-4)
8	8	NAS1149D0463J	WASHER
4		QS100M24S	CLAMP

4.0 WEIGHT AND BALANCE

There is a negligible weight and balance change associated with this modification.

DESIGN	ML	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ML		
CHECKED	q	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9750	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTALL MODIFICATION	NTS
DATE	16.06.01	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Change Record

PAGE 1 OF 1

Part Number: D135-692-041

Description: BEARPAW WEARPLATE INSTALLATION

[illegible]